

Date: Thursday, 1/17/2008 3:23:52 PM
 User: Kim Johnston

Process Sheet

SPIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT
 Job Number : 36811B
 Estimate Number : 10462
 P.O. Number :
 This Issue : 1/17/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL /MED FAB
 Previous Run : 36119B
 Part Number : D32782
 Drawing Number : D3278 REV. C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 1/24/2008 Qty: 225 Um: Each
 Written By :
 Checked & Approved By : 408 0118
 Comment : Est:A 04.04.19 New issue KJ/JLM
 Est B 07.09.06 Rev C dwg EC Verified by: JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.2454 f(s)/Unit Total: 40.3062 f(s) 55.215 f

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: m107129

C208/02/15 55.215

2.0 SHEAR SHEAR



Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.558" long

N/A
4/10/08 10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

1.1 ISSUE No: 3055 C208/02/08 (225)
C10BUS.

4/10/08 145 1043/20 (80)
 2- Check and inspect for transport damage. Ensure a copy of CERT attached.
 1- Part no 1 Q1 #6 C208/03/15 (414)

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Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



145X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. J.

08/03/17

7.0

POWDER COATING

POWDER COATING



145

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107005

BR 08-03-18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



145

Comment: INSPECT POWDER COAT

FZ 08/03/18

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 80

8/3/18

SC

145X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



145

Comment: FINAL INSPECTION/W/O RELEASE

08/03/17

Job Completion



2008/3/18

145

DART AEROSPACE LTD		Work Order: 36811B
Description: Support		Part Number: D3278-2
Inspection Dwg: D3278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000					
0.359	+/-0.005					
0.609	+/-0.010					
0.250	+/-0.010					
1.480	+/-0.005					
R0.125	+/-0.010					
0.119	+0.005/-0.004					
2.439	+/-0.010					
1.980	+/-0.010					
R0.13	+/-0.030					
Ø0.257	+0.005/-0.000					
R0.375	+/-0.010					
0.875	+/-0.010					
0.500	+/-0.010					
R0.400	+/-0.010					
R1.00	+/-0.030					
1.720	+/-0.010					
R0.125	+/-0.010					
0.125	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

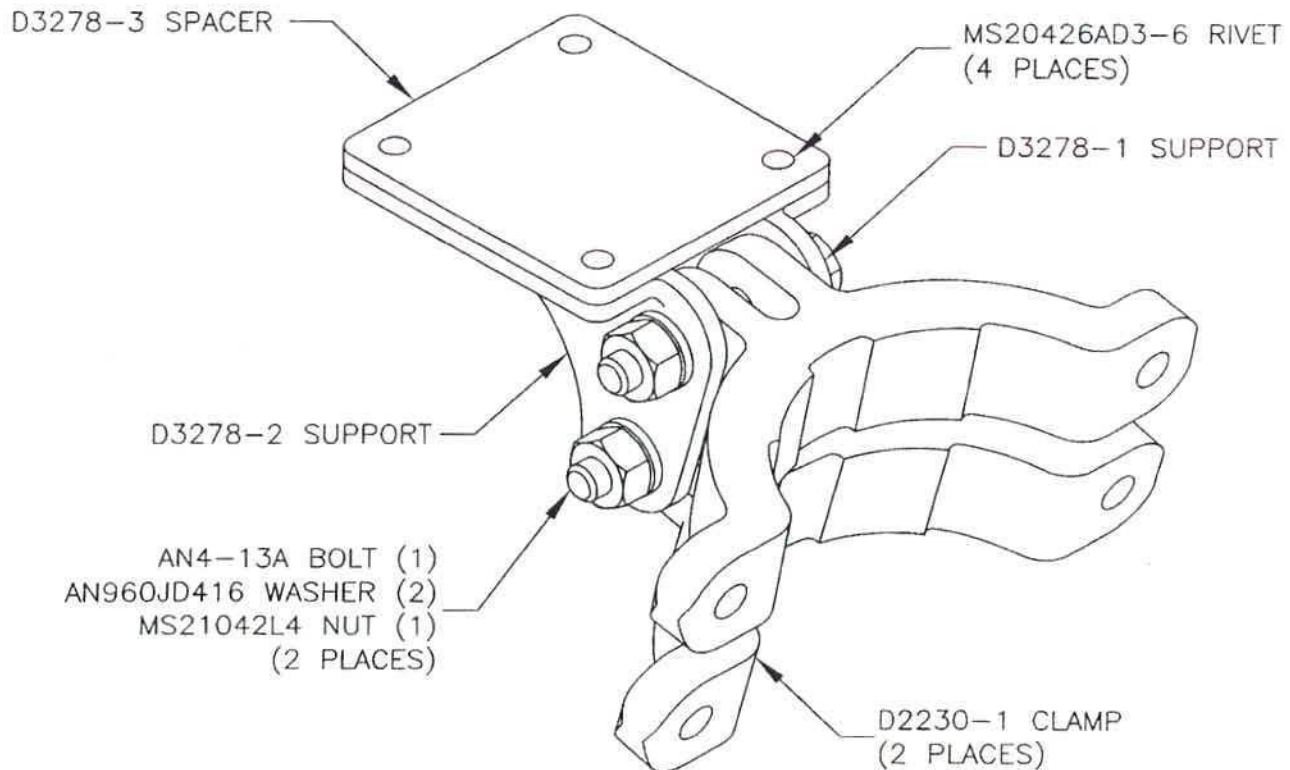
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	



DESIGN 97	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

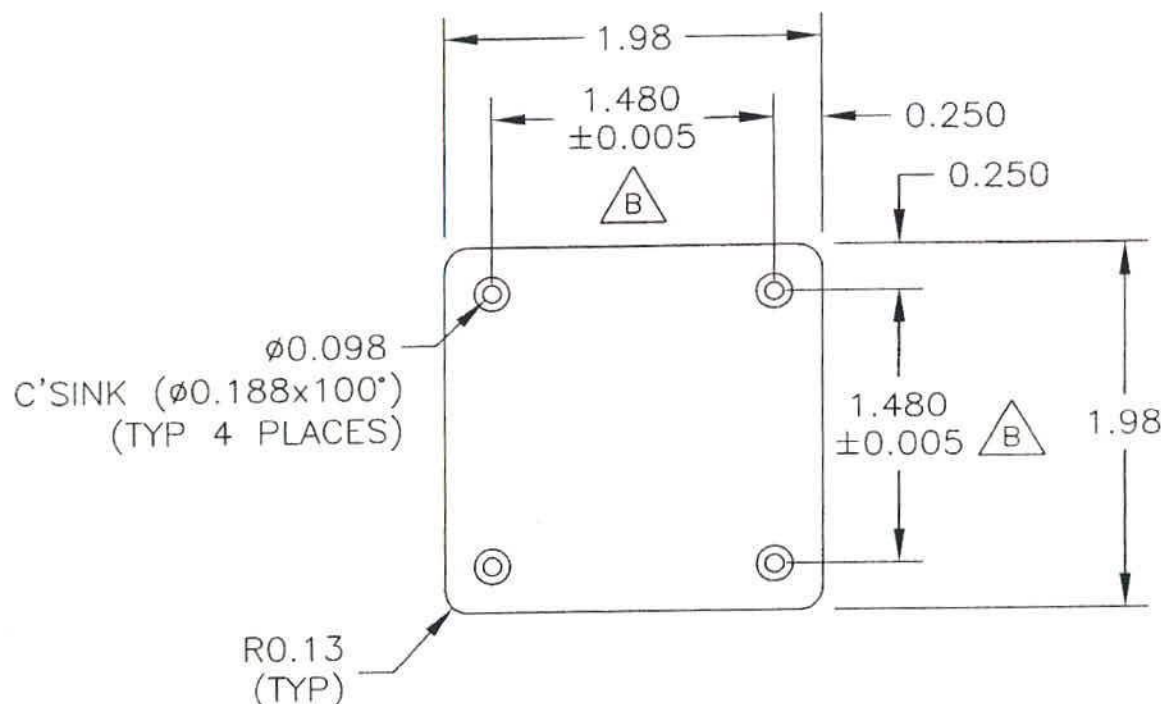
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DESIGN 97	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO REVISIONS
WITH NO. 36811B

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36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

Invoice

DATE	INVOICE NO.
3/12/2008	17006

BILL TO
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

SHIP TO
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
000005655	Net 30	3/12/2008	Pick-Up	632	Globus

QTY	DESCRIPTION
145	D3278-2 B36811B Support Business Number: 102122058

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts



Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579

DATE	INVOICE NO.
3/12/2008	17006

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SHIP TO
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
000005655	Net 30	3/12/2008	Pick-Up	632	Globus

QTY	DESCRIPTION	RATE	AMOUNT
145	D3278-2 B36811B Support Business Number: 102122058 <i>AC</i>	7.63	1,106.35T

WHITE = Original BLUE = C of C YELLOW = Packing Slip	GST	\$5.32
	PST	0.00
	TOTAL	\$1,161.67

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts